

Work Order ID 65947

Thursday, January 27, 2011 1:56:46 PM

Shp 28/01

Page 1

Item ID: D4073-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Hinge Backing Plate

Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/27/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: U

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4073

A

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-1-07

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B11-1-07

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

SL 11/01/27

(3)

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

3 AR 11-01-28.

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 115951.

3 BL 11-01-28.

Powdercoat

Memo

0.00

Powder Coating

POWDER COAT

Start Time:

Oven Temperature:

Finish Time:

7:40
320°
8:10

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Item ID: D4073-3

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Start Date: 1/27/2011 Start Qty: 2.00

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
160	Identify as per dwg & Stock Location: <u>119</u>	0.00							
Packaging Packaging	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

MUF
11-01-29

Picklist Print

Thursday, January 27, 2011 1:56:43 PM

Page 1

Work Order ID: 65947

Parent Item: D4073-3

Parent Item Name: Door Hinge Backing Plate

Start Date: 1/27/2011

Required Date: 1/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	214.5000	0.02777	0.058463			

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT

179.6

116308

35.6

116623

144

MAT21

34.9

113608

34.9

116308

3



11-1-07

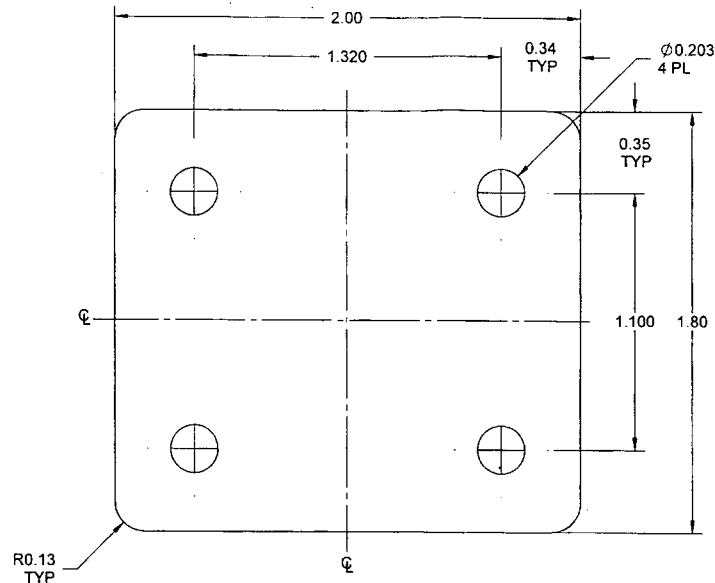
65947

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>SL</u>	Preliminary Approval:
Date: <u>11-1-27</u>	Date: <u>11/01/27</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ 	



D4073-3 DOOR HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

w/o 65947

RELEASED
2010-09-23
NO

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4073	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOOR HINGE	NTS
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